

Date: Thursday, 20/11/2008 3:30:54 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 43581
 Estimate Number : 12875
 P.O. Number :
 This Issue : 20/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LARGE FAB ASSY
 Previous Run : 40922
 Written By :
 Checked & Approved By : JLD 08.11.21
 Comment : Est Rev:B Added D3165-1 KJ/JLM 05-09-09

Drawing Name : HELI ACCESS STEP EXT HIGH GEAR RH
 Part Number : D205633026
 Drawing Number : DSI 9300 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 15/12/2008 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



for JLD 08/12/03



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD205-633-026

CHG001

09/01/02

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Spacer

Batch: 1330543

4.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Batch: 1338329

5.0

D2562005

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: 1323224

35045

43745x

8/12/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 43581

Part Number: D205633026

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D3438042

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Weldment Assembly

Batch: B 434777

13/9/06

SD

7.0

D31651

Support Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Support Arm

Batch: B365227

B23234

40683

SD

8.0

D2565301

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: B40680

B43747x3

28 09/01/09

SD

9.0

D2565303

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: B26640

B20849

B43747x3

SD

10.0

D2565305

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: B20850

B40681

B43748x2

28 09/01/09

SD

11.0

D2565307

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: B40682

B43749x3

28 09/01/09

SD

12.0

D2565309

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: 20852

24448

26443

8/12/29

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC-Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 43581

Part Number: D205633026

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D3437045

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 3

Aft Strut Assembly

Batch: 41932

43776

SP

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108672

SP

15.0

AN46A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: M108558

SP

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108077

SP

17.0

AN412A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109297

SP

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107534

SP

19.0

AN44 7A

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

EYEBOLT

Batch: M117653

*****ENSURE THIS IS AN44-7A EYEBOLT*****

M108638

8/12/29

(ix)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 43581

Part Number: D205633026

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 AN514A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M100166

21.0 AN960JD416 Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M109249

22.0 AN960JD516 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Batch: M109752

23.0 MS21042L4 Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Nut

Batch: M108145

24.0 MS21042L5 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

25.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-026

Location: _____

PPP Rev: _____

Rev A

8/12/29
S 02/06/12 (4) RTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR RH

Job Number: 43581

Part Number: D205633026

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in lb -8.06 m kg	94.5 in 2.40 m	1323 in lb 15.24 m kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in lb +7.62 m kg	94.5 in 2.40 m	1247 in lb 14.40 m kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in lb -8.26 m kg	94.5 in 2.40 m	1351 in lb 15.6 m kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in lb +7.80 m kg	94.5 in 2.40 m	1276 in lb 14.74 m kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in lb -8.43 m kg	94.5 in 2.40 m	1380 in lb 15.94 m kg
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in lb +7.96 m kg	94.5 in 2.40 m	1304 in lb 15.05 m kg

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WITHOUT NOTICE
WORK ORDER
NO. 43581

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED



BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

PARTS LIST

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED

CANADA
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BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)DATE: 05.08.12
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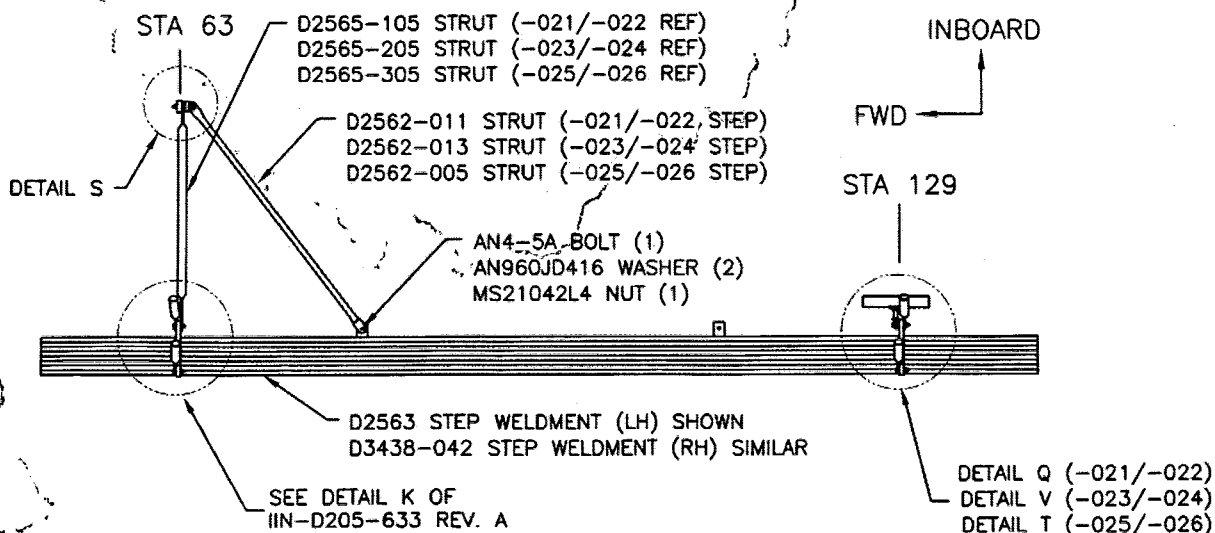
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP KIT		SCALE NTS

INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.



D205-633-021/-023/-025 SHOWN.

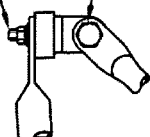
D205-633-022/-024/-026 SIMILAR

(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)

AN4-6A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)

DETAIL S
NOT TO SCALE



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BY: *[Signature]*
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 4 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS

→ R
INBOARD
→
FORWARD

STA 129

D3437-041 AFT STRUT
ASSEMBLY (REF)AN4-11A BOLT (1)
D2202-101 SPACER (2)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)**DETAIL Q**
NOT TO SCALEAN4-6A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)
(2 PLACES)

D2565-109 STRUT

D2565-107 STRUT

D2563 (REF)

0.50

1.50

DETAIL WDRILL Ø0.257 THRU,
TOUCH UP WITH
ALODINE 1200 OR 1201
PER MIL-C-5541 AS SHOWN

SEE DRILLING DETAIL W

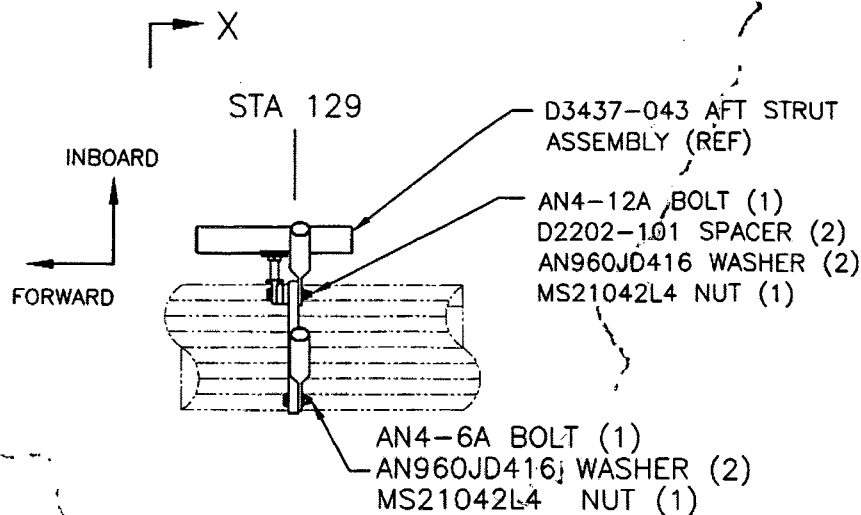
D3437-041
AFT STRUT ASSEMBLY (1)
ADJUST LENGTH TO SUITSIMPLEX MODEL 304 FIRE
ATTACK TANK (REF)**(-021/-022 STEP)**SHOP COPY
RETURN TO
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D. SHEPHERD (DE #02)DATE: 05.08.12
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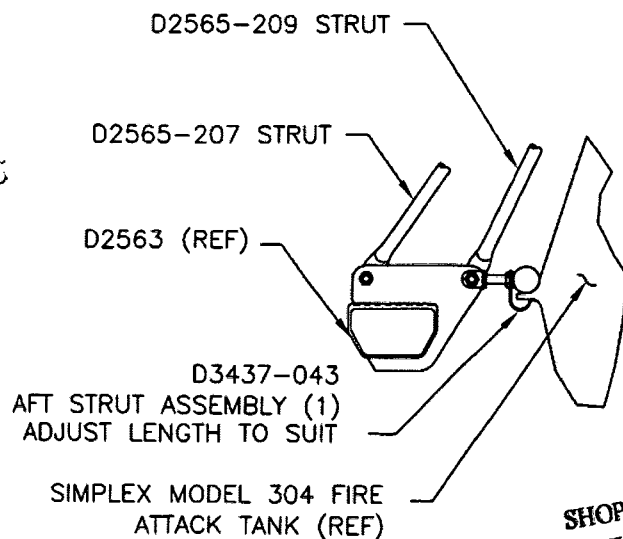
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 5 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



DETAIL V
NOT TO SCALE



(-023/-024 STEP)

VIEW X-X
NOT TO SCALE

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WITHOUT NOTICE
WORK ORDER
NO. **43581**

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BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

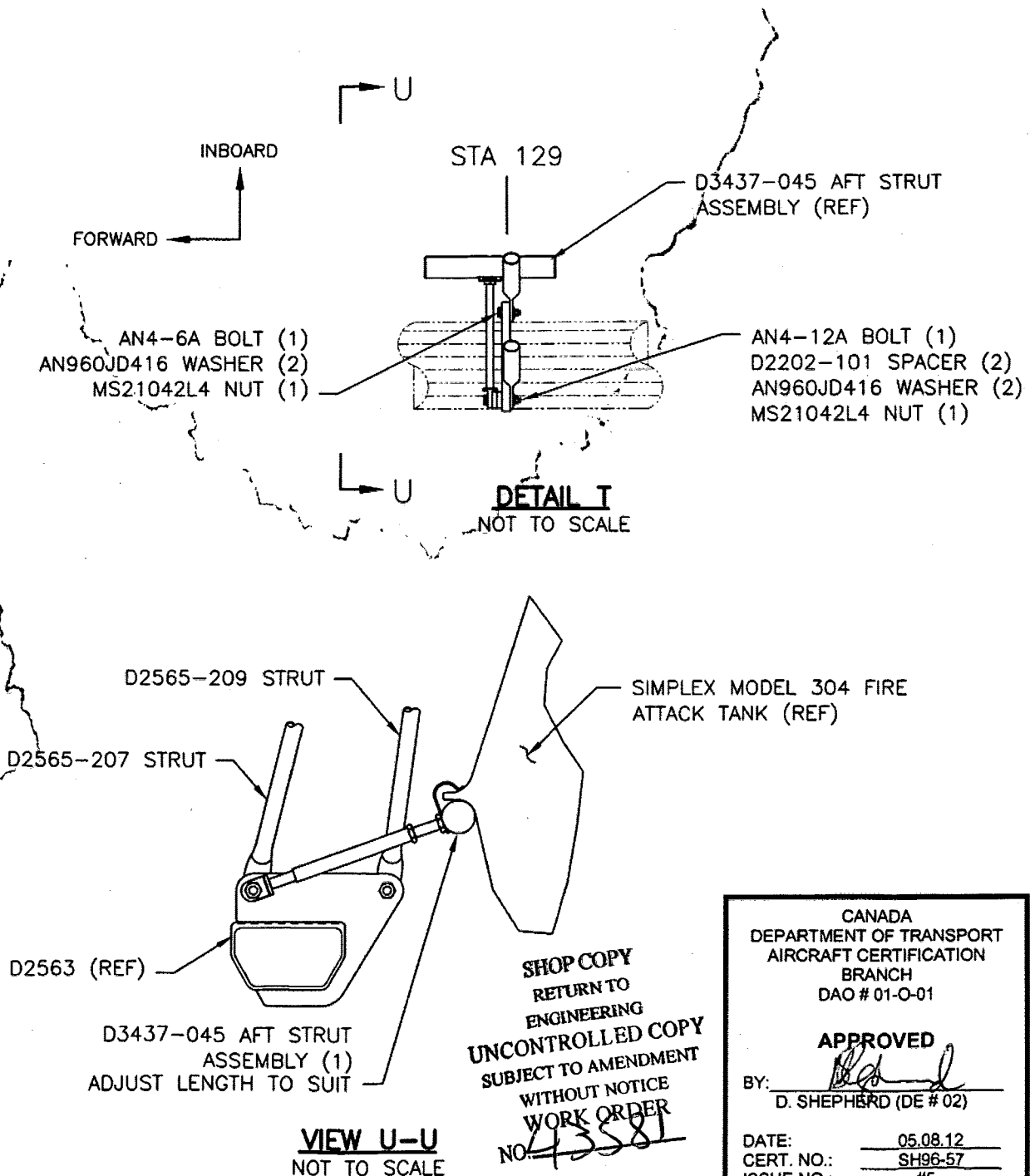
DATE: 05.08.12
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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